

Work Order ID 66102

Friday, February 04, 2011 12:36:10 PM



RUS

Page 1

Item ID: D3137-5

Accept



Setup Start



Revision ID:

Item Name: Washer

Stop



Start Date: 2/4/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 2/4/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan: *MUF*

Date: 11-02-04 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3137

Rev F

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-Machine as per Folio FA471 and Dwg D3137
2-Identify as D3137-5
3-Deburr*11-2-4**11*

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*11-2-4**11*

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

*J.F.S. 11/02/04**11*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification • Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

~~11/2/11~~ 11/2-03 11

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

11/2/11 11/2

160

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

11/2/11 11/2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Item Name: Washer

Start Date: 2/4/2011 Start Qty: 10.00

Required Date: 2/4/2011 Req'd Qty: 10.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

CZ 1/02/04.

CZ 1/02/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 66102



Parent Item: D3137-5



Parent Item Name: Washer

Start Date: 2/4/2011

Required Date: 2/4/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP ☐ A ☐ 04.11.04 ☐ New issue ☐ KJ/JLM ☐
IPP Rev B 08.07.03 ECN1207 EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.750 		Purchased	No			100	f	47.7648	0.0208	0.218947			
6061-T6 Round Bar .750"													



ML 11-2-4

Location	Loc Qty	Loc Code
MAT	47.748	
115469	0.0027	
115869	2.4453	
116406	45.3	
MAT012	0.016842105	
112442	0.01684211	

275

W/O:		WORK ORDER CHANGES						
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NOTE: Date & initial all entries

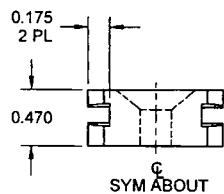
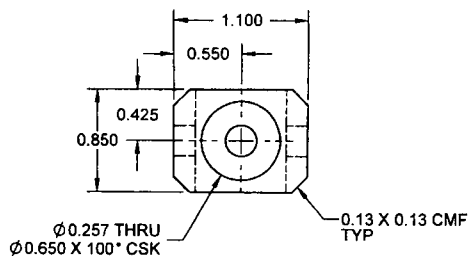
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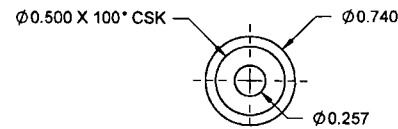
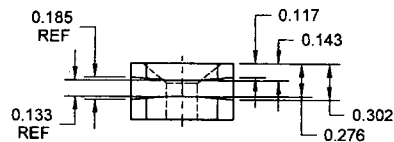
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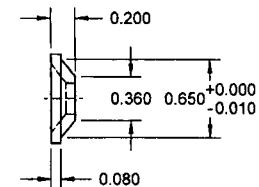
NOTE: Date & initial all entries



D3137-3 GUIDE



D3137-5 WASHER



NOTES:

- 1) MATERIAL: -3
DELIN II 150E OR ACETRON GP ACETAL, BAR
(REF DART SPEC M-DELIN-B)
-5
6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) ALUMINUM BAR
PER-AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4145/ 4116)
OR PER-QQ-A-200/8 (OR AMS 4160)
REF. DART SPEC M6061T6R
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 (-5 ONLY)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE ASSEMBLED WEIGHT ON SHEET 2
- 8) -3 REPLACES PREMIER P/N B30-2300-207
-5 REPLACES PREMIER P/N B30-2300-209

#66102

RELEASED
180702/14

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	J.AJS		
CHECKED	J	DRAWING NO.	REV. F
MFG. APPR.	41	D3137	SHEET 5 OF 5
APPROVED	42	TITLE	SCALE
DE APPR.	43	BRACKET ASSEMBLY	NTS
DATE	08.05.30	<small>COPYRIGHT © 2003 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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